

Work Order ID 151300

151300

Page 1

Tuesday, September 20, 2016 1:41:54 PM

Item ID: D4381-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: X-Tube Strap Bumper
Start Date: 9/20/2016 Start Qty: 100.00 *100* Cust Item ID:
Required Date: 10/4/2016 Req'd Qty: 100.00 *100* Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: SEP 20 2016 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4381	A

100 PURCHASING 0.00 SEP 21 2016 100 DAS 13 9-89

100 Purchasing
Purchasing
Memo
Issue P/O: 33731
Manufacture as per Dwg D4381
Possible Supplier: VIP Rubber Company, Inc
Material release note required

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110 Packaging
Packaging
Memo
Ensure Material Release Note is attached

100 x Sp/6-12-20

120 QC6- Inspect dimensions to drawing 0.00

120 QC
Quality Control
Memo
NEED A 100% VISUAL INSPECTION FOR ALL RECEIVED PARTS, FOR
CRACKS OR LARGE VOIDS

112 16-12-23 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 151300***151300***

Page 2

Tuesday, September 20, 2016 1:41:54 PM

Item ID: D4381-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: X-Tube Strap Bumper

Start Date: 9/20/2016 Start Qty: 100.00

100

Cust Item ID:

Required Date: 10/4/2016 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 5103A

0.00

130

Packaging

Memo

0.00

Packaging

112

JAN 06 2017

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
21
9-89

JAN 06 2017



JAN 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Tuesday, September 20, 2016 1:41:56 PM

Page 1
4

Work Order ID: 151300

151300

Parent Item: D4381-1

D4381-1

Parent Item Name: X-Tube Strap Bumper

Start Date: 9/20/2016

Required Date: 10/4/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 11.05.10 new issue DD verf;JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4381-1P		Purchased		No		110	Each	0.0000	1	100			
D4381-1P									**	100x			
X-Tube Strap Bumper													

sp/6-12-20.
112x.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

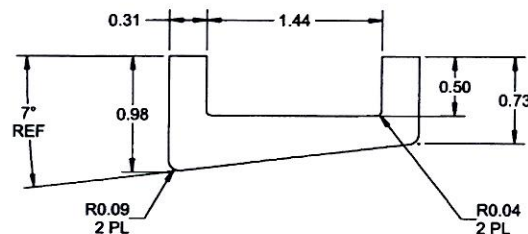
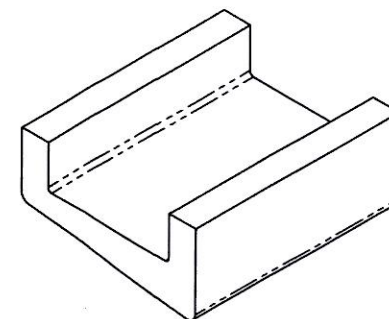
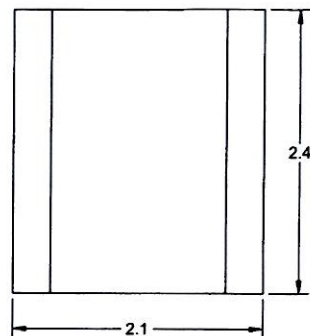
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151300 MJS

1609-20



D4381-1 X-TUBE STRAP BUMPER

NOTES:

- 1) MATERIAL: POLYURETHANE, 80-85 DUROMETER, BLACK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs APPROX

RELEASE
2011-11-02

A		NEW ISSUE		AJS	11.04.13
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	UP	DRAWING NO. D4381		REV. A	
MFG. APPR.	CS				SHEET 1 OF 1
APPROVED	UP	TITLE			SCALE
DE APPR.	UP	X-TUBE STRAP BUMPER			NTS
DATE	11.04.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33731

Purchase Order Date 9/21/2016 1:46:55 PM
PO Print Date 9/21/2016

Page Number 1 of 2

Order From :

VU-VIP001

Ship To : DART AEROSPACE LTD

VIP RUBBER COMPANY INC.
540 SOUTH CYPRESS STREET
LA HABRA, CA 90631
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

SEP 21 2016

Contact Name

Vendor Phone 562 905 3456

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FOB Origin

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4381-1P AS PER DWG D4381 REV. A B151300 MATERIAL: POLYURETHANE, 80-85 DUROMETER, COLOR BLACK	X-Tube Strap Bumper	10/12/2016 Yes 10/12/2016		100.00 Each	\$5.77	\$577.00

Line Total:

\$577.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	10/12/2016 No 10/12/2016		1.00	\$0.00	\$0.00
Procurement Quality Clauses							
A004 faa-pma/tso							
A005 right of entry							
A016 personnel qualification							
A025 certification of conformance							
A040 notification of quality escape							
A043 retention of quality documents							

Line Total:

\$0.00

Note:

9/21/2016

All Materials
Rubber
Plastic
TPE
Molding
Sheeting
Extrusion
Fabrication



VIP Rubber Company, Inc.

540 S. Cypress Street
La Habra, CA 90631
(562) 905-3456 (Phone)
(562) 905-3460 (Fax)
www.viprubber.com



Rubber / Plastic
Metal Bonding
Silicone
PSA
Sponge
Cut To Length
Co-Extrusion
Hot Melt Tape
And More...

Location: 100

*****PACKING LIST*****

INVOICE DATE 12/16/2016

INVOICE NUMBER: 457253

SOLD TO: DART AEROSPACE LTD
HAWKESBURY, ONTARIO
CANADA, K6A 1K7

SHIP TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ONTARIO
CANADA, K6A 1K7

DATE	PURCHASE ORDER NUMBER	CUST #	F.O.B.	SALESPERSON
12/16/2016	PO33731	3626	ORIGIN	VIP HOUSE ACCOUNT
TERMS		SHIP VIA		
NET 30 DAYS		FEDEX P1 COLLECT		
SHIPPED	DESCRIPTION	PRICE	TOTAL	
100.00 PCS	VIP PART ID: 6344 D4381-1P X-TUBE STRAP BUMPER BLACK DWG #: D4381 REV A 84/CAST URETHANE LOT #:4052561 DAS 9-89		SP/6-12-20	

ORDER COMPLETE.....THANK YOU

SHIPPING 1 CTN @ 11#

WE APPRECIATE YOUR BUSINESS
BUY AMERICAN

MERCHANDISE NOT RETURNABLE AFTER 30 DAYS

The goods hereby sold are warranted free from defects in workmanship and materials for sixty (60) days from shipment to Buyer. No other express warranty is given no affirmation of Seller, by words or action, shall constitute a warranty.

This warranty shall be limited to the repair or replacement of parts and the necessary labor and services required to repair the goods, or, at Seller's option, a refund of the purchase price, provided that the defect is reported to Seller and the goods are returned to the Seller within the warranty period. This warranty does not cover the results of ordinary wear and tear, or any part damaged by neglect, misused, accident, excessive deterioration due to corrosion from any cause, improper operation or maintenance, or any part damaged in the course of or as a result of installation, modification or adjustment performed by anyone other than the Seller or its authorized representative.

IT IS EXPRESSLY AGREED THAT THIS LIMITED WARRANTY SHALL BE IN LIEU OF ALL OTHER WARRANTIES OF FITNESS AND IN LIEU OF THE WARRANTY OF MERCHANTABILITY. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION OF THE FACE HEREOF.

It is expressly agreed that the replacement, repair or return of the goods and repayment of the purchase price, SHALL BE THE SOLE AND EXCLUSIVE REMEDIES OF BUYER with respect to any non-conforming goods and parts thereof and shall be in lieu of any other remedy available by applicable law. Seller in no event shall be liable for consequential damages arising out of or in connection with this sale of goods, including without limitation breach of contract or repudiation by Seller. Consequential damages shall include, without limitation, loss of use, income or profit, or losses sustained as a result of injury (including death) to any person or loss or damage to property. The foregoing terms cannot be waived or modified except by a writing signed by Seller.

A LATE CHARGE OF 1% PER MONTH (18% PER ANNUM) WILL BE MADE ON PAST DUE BALANCES.

All Materials
Rubber
Plastic
TPE
Molding
Sheeting
Extrusion
Fabrication



VIP Rubber and Plastic Company, Inc.

540 S. Cypress Street
La Habra, CA 90631
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(562) 905-3460 (Fax)
www.viprubber.com



Rubber / Plastic
Metal Bonding
Silicone
PSA
Sponge
Cut To Length
Co-Extrusion
Hot Melt Tape
And More...

CERTIFICATION OF CONFORMANCE

THIS IS TO CERTIFY THAT THE MATERIAL FURNISHED ON THIS PURCHASE ORDER WAS
MADE IN STRICT ACCORDANCE WITH THE NOTED SPECIFICATION

Bill To:

DART AEROSPACE LTD
HAWKESBURY, ONTARIO
CANADA, K6A 1K7

Ship To:

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ONTARIO
CANADA, K6A 1K7

Lot #: 4052561

Shipper ID: 457253

Part Number: D4381-1P

DWG#: D4381 REV A

Customer PO: PO33731

Cure Date: 4Q16

Date Shipped: 12/16/2016

Description: X-TUBE STRAP BUMPER

Quantity

Ordered

100 PCS

Shipped

100 PCS

Specification:

84/CAST URETHANE

Quality Assurance